
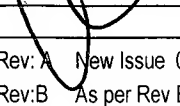


Date: Thursday, 13/09/2007 11:08:31 AM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUMP OUTLET
Job Number	: 34654		
Estimate Number	: 12166		
P.O. Number	: N/A	Part Number	: D3475041
This Issue	: 13/09/2007 S.O. No. : N/A	Drawing Number	: D3475 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28544	Material	: N/A
Written By	: 	Due Date	: 20/09/2007
Checked & Approved By	: 	Qty:	6 Um: Each
Comment	: Est Rev: A New Issue 06-02-03 JLM Est Rev: B As per Rev B 06-05-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34753	TUBE
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3475-1	Tube	B 34394

D3475-3

2.0	D34751	OUTLET ADAPTER PLATE
-----	--------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3475-1	Flange	B 34393

3.0	NAS1031C3W	Nutplate
-----	------------	----------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) 40

Pick:

Qty	Part Number	Description	Batch
8	NAS1031C3W	Nut Plate	M105569 X 25 M105559 X 15

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

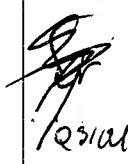
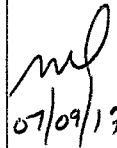

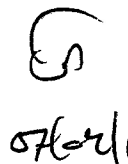



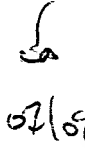
1-Assemble as per Dwg D3479

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/17	4	Bad Assy when welding	 J. Smith	one D3475-041 No good Scrap it and No replace	 J. Smith 07/09/17	En Atollig 07/09/18	 J. Smith 07/09/18	 J. Smith 07/09/18
07/09/18	4 y.10	Parts are too long by 0.0004	 J. Smith	Parts are acceptable	 J. Smith 07/09/18	En 07/09/18	 J. Smith 07/09/18	 J. Smith 07/09/18

NOTE: Date & initial all entries

Date: Thursday, 13/09/2007 11:08:31 AM  
User: Linda Lacelle

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUMP OUTLET

Job Number: 34654

Part Number: D3475041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Spot Weld as per Dwg D3475 and Dart QSI 018

ml 07/09/17 (X5)

5.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/09/17 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/18 (45)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock  
Location: \_\_\_\_\_

07/09/18 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/18/19 (5)

Job Completion



U 07-09-19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

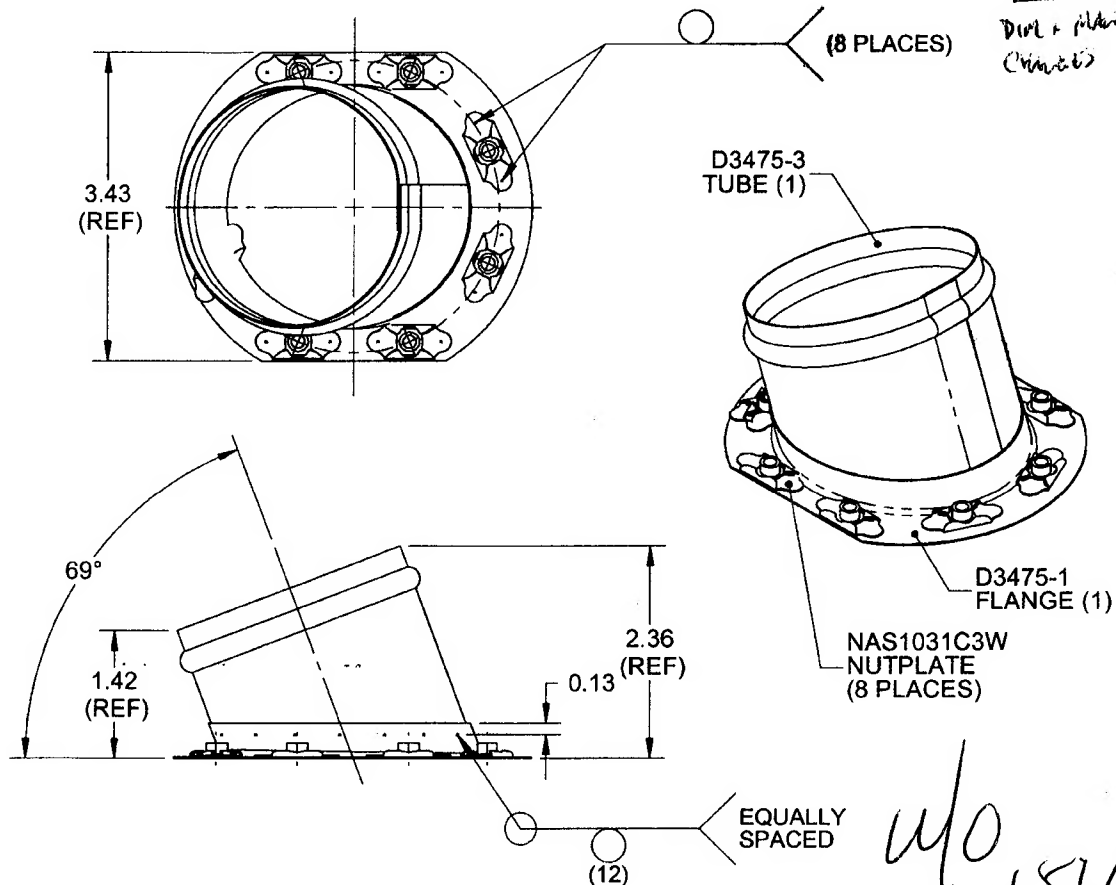
**NOTE:** Date & initial all entries

**DART****RELEASED**  
06-05-16

DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3475</b>	REV. B SHEET 1 OF 7
DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:2
A	06.01.24	NEW ISSUE	
B	06.05.16	REDESIGN D3475-1F/-5/-7S/-7; ADD D3475-9	

**UNDER REVIEW**

02.04.13

Dirt + Manufacturing  
(Notes)**D3475-041 DUMP OUTLET****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3475-041	DUMP OUTLET
1	D3475-1	FLANGE
1	D3475-3	TUBE
8	NAS1031C3W	NUTPLATE

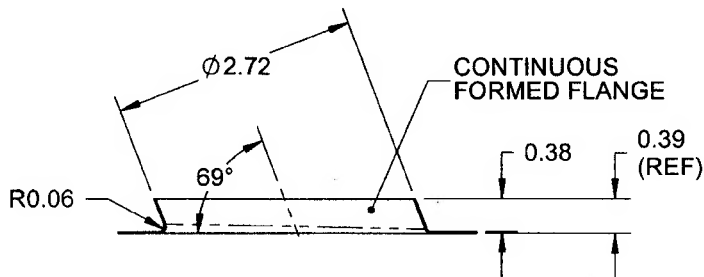
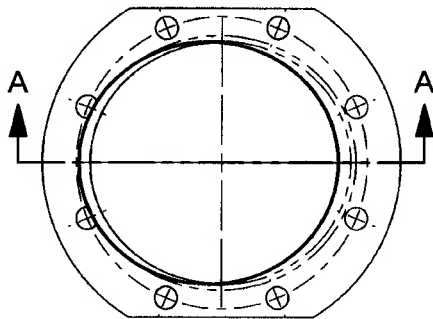
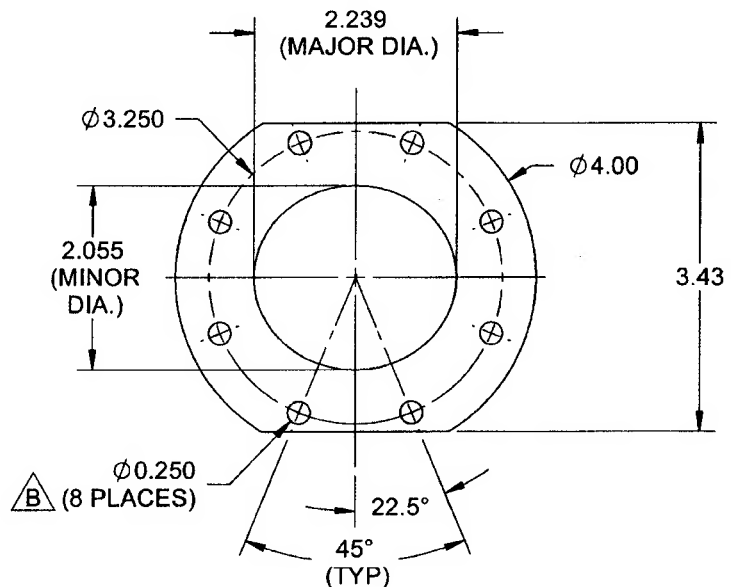
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775

**DART**

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3475</b>	REV. B SHEET 2 OF 7
DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:2

**SECTION A-A****D3475-1 OUTLET  
ADAPTER PLATE****D3475-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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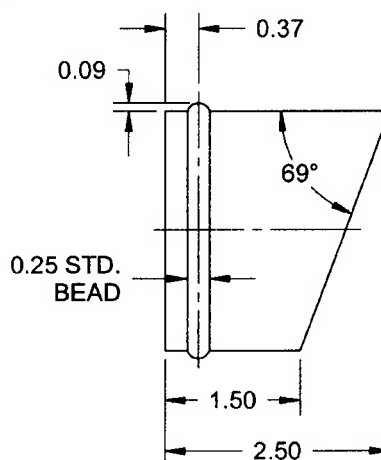
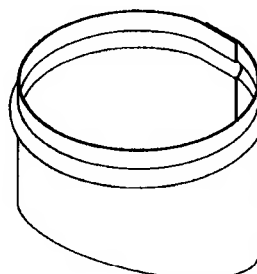
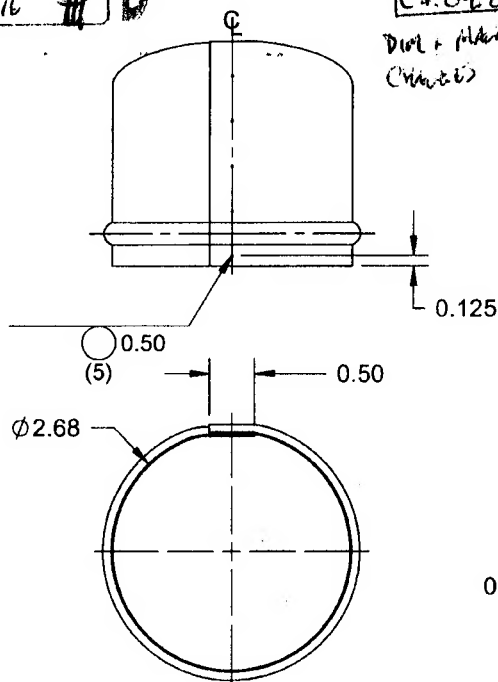


DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3475</b>	REV. B SHEET 3 OF 7
DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:2

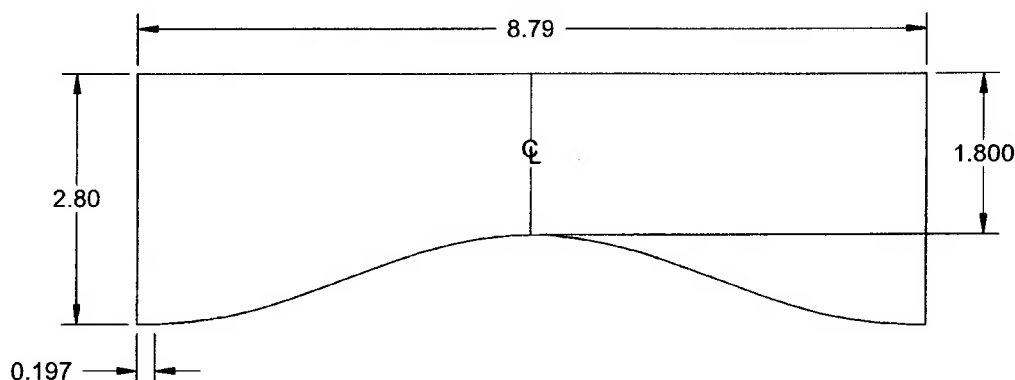
**RELEASED**  
06.05.16 *#*

**UNDER REVIEW**  
07.09.16 *B*

*Dial + planifactor  
(check)*



**D3475-3 TUBE**



**D3475-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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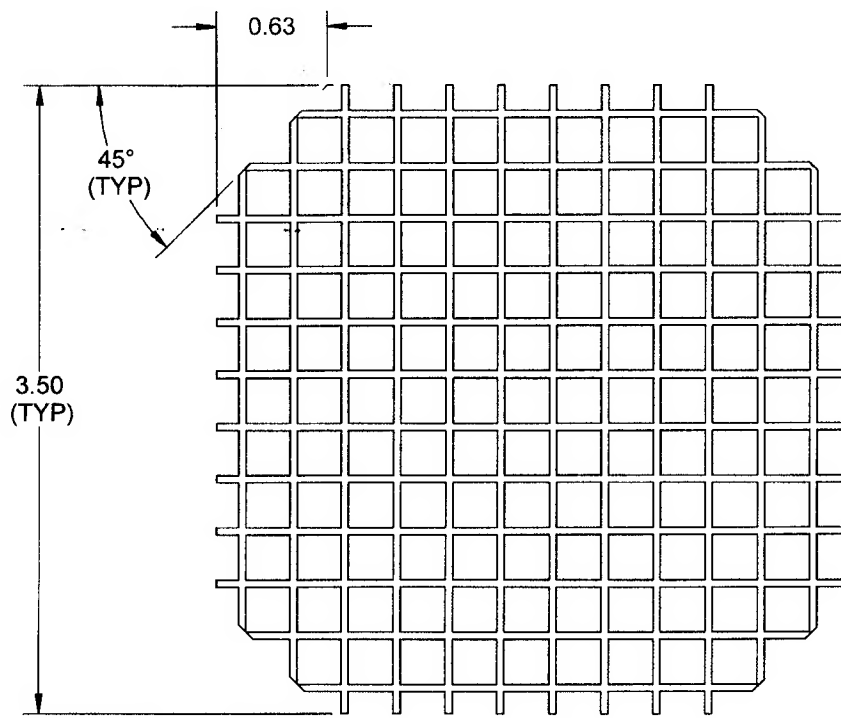


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3475</b>	REV. B SHEET 4 OF 7
DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:1

UNDER REVIEW

*02.09.16*  
*Dirt + Alder Fabrication*  
*(M.B.)*

RELEASED  
*06.05.16*



### **D3475-5 SCREEN**

#### **NOTES:**

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING,  $\phi$ 0.047" WIRE  
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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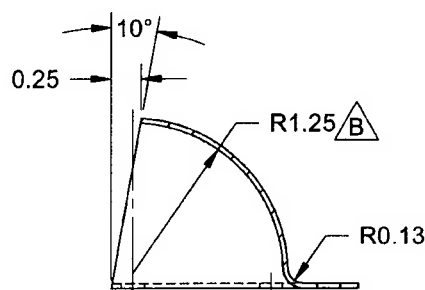
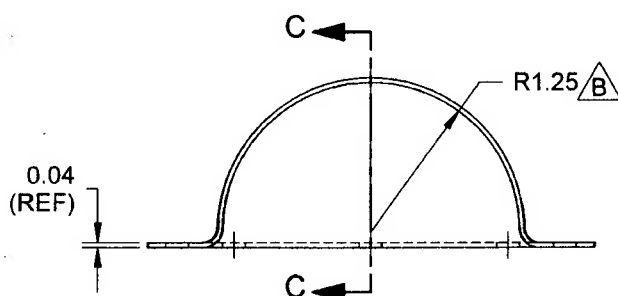
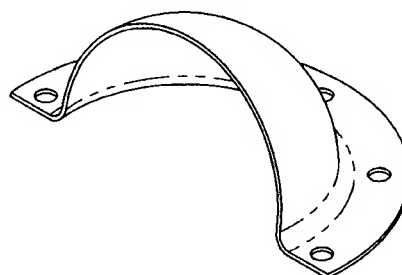
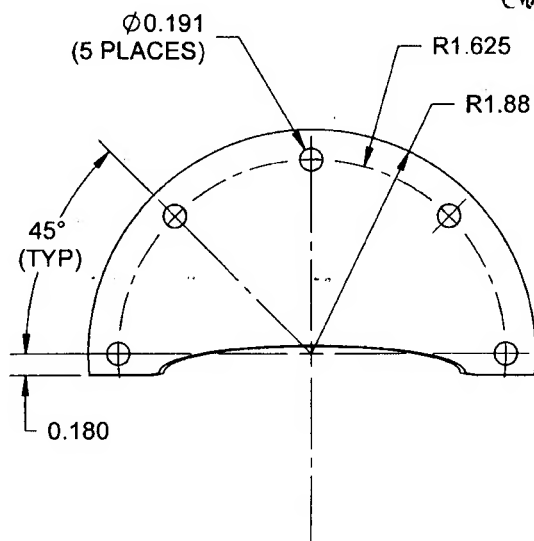


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3475	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

UNDER REVIEW

*02.09.02*  
*Dial + planification*  
*Chait*

RELEASED  
*06.05.16*



**SECTION C-C**

**D3475-7 SCOOP OUTLET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) IDENTIFY WITH DART P/N D3475-7 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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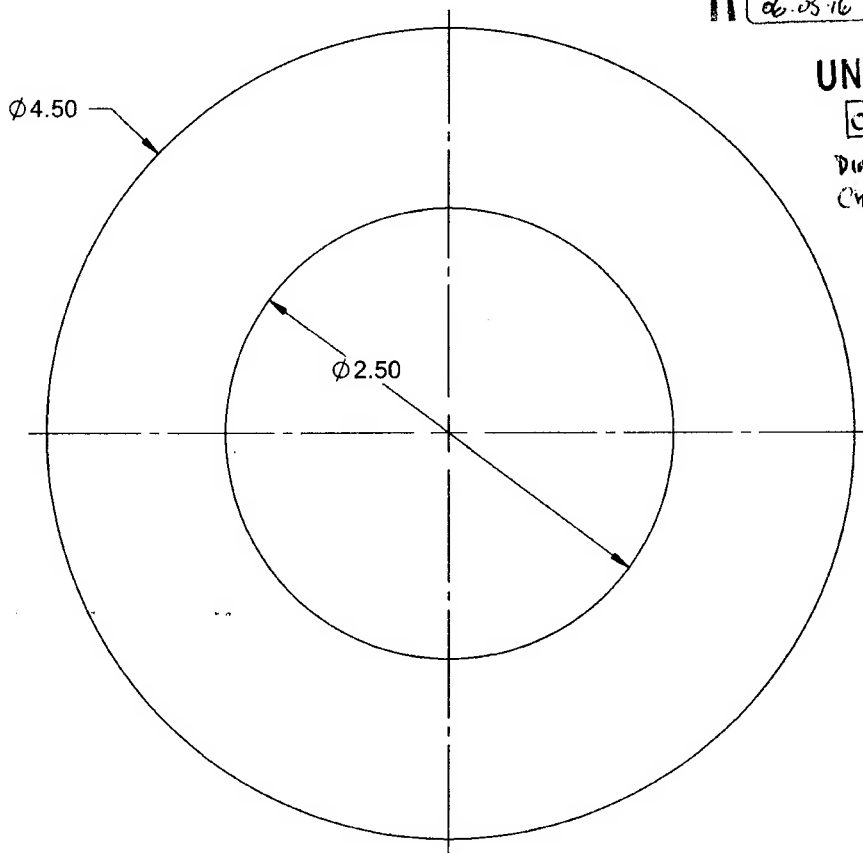
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3475</b>	REV. B SHEET 7 OF 7
DATE <b>06.05.16</b>		TITLE <b>DUMP OUTLET</b>	SCALE 1:1

**RELEASED**  
*[Signature]* 06.05.16

**UNDER REVIEW**

*[Signature]* 02.09.16

DIOL + MANUFACTURING  
(Chen)



### **D3475-9 OUTLET GASKET**

#### **NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 15

EMPLOYEE: Monique hepcie

PART NUMBER: D3475-041

JOB NUMBER: B 34654

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .078

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium

## TEST RESULTS

	PASS	FAIL
VISUAL:	<input checked="" type="checkbox"/>	<input type="checkbox"/>
PENETRATION:	<input checked="" type="checkbox"/>	<input type="checkbox"/>
PULL STRENGTH:	<input checked="" type="checkbox"/>	<input type="checkbox"/>

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/09/17

QUALIFIER: SD